

## Claims 1-26 (Cancelled)

27. (Currently Amended) A method for threading a material web in a web processing machine including:

providing at least a printing unit in said web processing machine;

providing a web receiving area in said web processing machine and before, in a direction of web travel, said printing unit;

providing a web delivery area in said web processing machine and after, in said direction of web travel, said printing unit;

providing a web threading path extending in said direction of web travel between said web receiving area and said web delivery area and through said printing unit in said web processing machine;

providing a web threading means adapted for receiving a leading end of said material web;

using said web threading means for engaging and for threading said leading end of said material web through said web processing machine and from said web receiving area to said web delivery area during movement of said web threading means in a web threading operation of said web processing machine;

providing a first web threading means drive motor at said web receiving area before said printing unit and having a first motor strength;

providing a second web threading means drive motor at said web delivery area after said printing unit and having a second motor strength;

providing said second motor strength greater than said first motor strength;

regulating operating said first web threading means drive motor in said web receiving area at for maintaining a regulated first motor holdback torque of said first web threading means drive motor and applied to said web threading means during said web threading operation of said web threading means and said material web through said web processing machine and including said printing unit;

regulating operating said second web threading means drive motor at in said web delivery area at for maintaining a predetermined regulated web threading speed of said second web threading means drive motor and applied to said web threading means during said web threading operation of said web threading means and said material web through said web processing machine and including said printing unit;

setting said regulated motor holdback torque of said first web threading means drive motor and setting said regulated web threading speed of said second web threading means drive motor for pulling said web threading means and said engaged leading end of said material web through said web processing machine, and said included printing unit, from said web receiving area and to said web delivery area; and

maintaining a constant tension in said material web during said pulling of said web threading operation means and said material web through said web processing machine during said web threading operation by regulating said operating of said second web threading speed of said second means drive motor at said regulated web threading speed and by regulating said operating of said first web threading means drive motor at said regulated motor holdback torque of said first drive motor; and,

using said second web threading means drive motor and pulling said web threading means through said web processing machine and said included printing unit from said web receiving area to said web delivery area against said regulated motor torque of said first web threading means drive motor.

28. (Cancelled)

29. (Currently Amended) The method of claim 27 further including providing a frequency converter and using said frequency converter for regulatingoperating one of said first and second motors.

30. (Previously Presented) The method of claim 27 further including providing first and second reel bodies about which said threading means is alternately wound and unwound and using each of said first and second motors for driving respective ones of said first and second reel bodies.

31. (Currently Amended) The method of claim 30 further including regulatingoperating at least one of said first and second motors depending on a current diameter of at least one of said first and second reel bodies.

32. (Previously Presented) The method of claim 31 further including providing a control device and using said control device for determining a target value of a frequency load to said at least one of said first and second motors depending on said reel body current

diameter.

33. (Previously Presented) The method of claim 31 further including determining said current reel body diameter depending on a number of layers of said threading means wound on said reel body and a thickness of said threading means and further depending on an initial diameter of said reel body.

34. (Previously Presented) The method of claim 33 further including providing a rotation sensor on one of said reel body and its drive, calculating a number of rotations of said reel body and using said number of rotations for determining said number of layers of said threading means wound on said reel body.

35. (Previously Presented) The method of claim 34 further including determining said number of rotations of said reel body in said receiving area.

36. (Previously Presented) The method of claim 34 further including determining said number of rotations of said reel body in said delivery area.

37-38 (Cancelled)

39. (Currently Amended) The method of claim 27 further including providing a rotary drive for at least one mechanically independent assembly of said web processing machine and correlating controls said operating of at least one of said first and second

motors and said drive with respect to speed.

40. (Currently Amended) The method of claim 27 further including providing a material web reel changer in said web receiving area and having a reel changer drive and controllingoperating one of said first and second motors and said reel changer drive correlated with each other with respect to their speed by using a machine control.

41. (Currently Amended) The method of claim 27 further including providing a printing unit drive for said printing unit and further including controllingoperating said second motor and said printing unit drive correlated with each other with respect to speed by using a machine control.

42. (Currently Amended) The method of claim 27 further including providing a control device including a servo control and using said servo control for driving said first motor at said regulated motor holdback torque.

43. (Currently Amended) A device for threading a web of material into a web processing machine comprising:

    a printing unit in said web processing machine;  
    a web threading device adapted to receive a leading end of a web to be threaded through said web processing machine;  
    a web threading path in said web processing machine and along which said web threading device is adapted to travel, said web threading path extending, in a

direction of web travel, between a web receiving area before said printing unit and a web delivery area after said printing unit and through said printing unit;

a first web threading device drive motor in said web receiving area before said printing unit and having a first motor strength and a second web threading device drive motor in said delivery area after said printing unit and having a second motor strength greater than said first motor strength;

means for regulating to operate said first motor with respect to maintain a regulated first motor holdback torque during said threading of a web of material along said web threading path;

means for regulating to operate said second motor with respect to maintain a regulated second motor speed during said threading of a web of material along said web threading path and to maintain a constant tension in said web of material during said web threading, said second drive motor speed being adapted regulated to pull said web threading device through said web processing machine and said included, printing unit against said regulated holdback torque of said first web threading device drive motor;

at least one mechanically independent assembly in said web processing machine and operating at an assembly speed;

a machine control device in said web processing machine and being usable to provide correlated speed relevant input signals to said second motor and to said at least one mechanically independent assembly to synchronize said speed of said second motor and said assembly speed of said at least one mechanically independent assembly; and

an electronic guide axis for said machine control and being usable to provide said speed relevant input signals for said speed control of said second motor and for said assembly speed of said at least one mechanically independent assembly.

44. (Previously Presented) The device of claim 43 further including a control device usable to produce a frequency signal based on a predetermined threading speed, and a signal connection between said second motor and said control device.

45. (Previously Presented) The device of claim 44 wherein said machine control is adapted to provide said control device with a target value for said predetermined threading speed.

46-48 (Cancelled)

49. (Previously Presented) The device of claim 43 further including a first reel body in said receiving area and a second reel body in said delivery area, each of said first and second motors being adapted to drive a respective one of said first and second reel bodies.

50. (Previously Presented) The device of claim 49 further including a rotation sensor on one of said first and second reel bodies.

51. (Previously Presented) The device of claim 44 wherein said control device includes

a calculating means usable to provide a frequency signal for said motor based on a predetermined threading speed and a number of rotations.

52. (Currently Amended) The device of claim 43 further including a control device usable to regulate said first motor with respect to said holdback torque.